

Work Order ID 116878

April-24-14 8:30:15 AM

116878

Page 1

Item ID: D4801-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Leg Assembly, RH
Start Date: 5/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/02/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: MLS Date: 11-04-25 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
D4801	<u>A B C</u>	<u>14.06.18</u>

110

0.00

110

Small Fab

Memo

0.00

Small Fab

ALIGN PILOT HOLES IN D4801-2 WITH PILOT HOLES IN D4805-1 AND
D4805-3. DRILL OUT EACH HOLES USING A PILOTED DRILL AS PER
DWG.
REAM EACH HOLES USING REAMER, USING DART TOOL SETUP
DT9952 AS PER DWG.

1 FF FEB 19 2015

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

DAS
38
9-891 FEB 23 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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116878

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April-24-14 8:30:15 AM

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 Item Name: Aft Leg Assembly, RH
 Start Date: 5/02/14 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/02/14 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	INSTALL PIN/COLLAR AND END FITTING WITH HYSOL WHILE STILL WET AS PER DWG USE DT9952 A/R HYSOL BATCH: <u>M131506</u>								
140	QCS- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									DAS 38 9-89 FEB 24 2015
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									

Purch:

Issue P/O. 27681 P+L printing

02 15/03/06 ①

note:

attached c/c to W/O

151

Inspector →

IX SP 15-03-12
 1
 DAS
 38
 9-89
 MAR 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21 - Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLS 150316

St 230

1

MAR 13 2015

D2
9-85

153-16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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April-24-14 8:30:19 AM

116878

D4801-042

Start Date: 5/02/14**Required Date:** 5/02/14**Start Qty: 1.00**

Required Qty: 1.00

Comments: IPP REV:A 14.01.16 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
HL20PB5-8 *HL20PB5-8* Rivet		Purchased	No				Each	76.0000		4			
									**		FF	FEB 18 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST281				66					
					M128110			6					
					M128579			60					
				ST284				10					
					M128429			10					
D4801-2 *D4801-2* Strut		Manufactured	No				Each	0.0000		1			
									**		FF	FEB 18 2015	
D4805-1 *D4805-1* End Fitting		Manufactured	No				Each	2.0000		1			
									**		FF	FEB 18 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				2					
					112022			2					
D4805-3 *D4805-3* End Fitting		Manufactured	No				Each	2.0000		1			
									**		FF	FEB 18 2015	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				2					
					112023			2					

DQA: _____ Date: _____



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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other _____ _____ _____
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Picklist Print

April-24-14 8:30:19 AM

Page 2

Work Order ID: 116878

116878

Parent Item: D4801-042

D4801-042

Parent Item Name: Aft Leg Assembly, RH

Start Date: 5/02/14

Required Date: 5/02/14

Start Qty: 1.00

Required Qty: 1.00

HL86-5

Purchased

No

Each

113.0000

4

HI 86-5

FF

FEB 10 2015

Collar

Location

Loc Qty

Loc Code

ST280

129064

16

M128110

16

ST284

97

M128228

97

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27681**

Purchase Order Date 3/6/2015

PO Print Date 3/6/2015

Page Number 1 of 3

Order From :

VC-PL001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

P & L PRINTING
19226 AIRPORT ROAD
SUMMERSTOWN, ONTARIO K0C 2E0
CANADA

Contact Name

Vendor Phone 613-931-1241

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	121632	D4802-041 LEG ASSEMBLY	3/16/2015 Yes 3/16/2015		6.00	\$4.00	\$24.00
	LASER MARKED						
						Line Total:	\$24.00
2	116504	D4802-041 LEG ASSEMBLY	3/16/2015 Yes 3/16/2015		4.00	\$4.00	\$16.00
	LASER MARKED						
						Line Total:	\$16.00
3	116878	D4801-042 AFT LEG ASSEMBLY	3/16/2015 Yes 3/16/2015		1.00	\$4.00	\$4.00
	LASER MARKED						

Note:

3/6/2015

SP 15-03-12



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

PACKING SLIP

SOLD TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

SHIPPED TO

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

DATE March 9, 2015

P.O NUMBER PO27681

ITEM DESCRIPTION	QUANTITY	COMMENTS
D4802-041 LEG ASSEMBLY	6 ✓	ALL ITEMS HAVE BEEN LASER MARKED SP15-03-12
D4802-041 LEG ASSEMBLY	4 ✓	
D4801-042 LEG ASSEMBLY	1 ✓	
D4801-042 LEG ASSEMBLY	2 ✓	
D4928-041 LEG ASSEMBLY	4 ✓	
D4928-042 LEG ASSEMBLY	4 ✓	
D4835-041 LEG ASSEMBLY	2 ✓	



19226 Airport Road
Summerstown, ON
K0C 2E0 Canada

Tel. 613-931-1241
Fax 613-931-2560
plprinting@bellnet.ca

Invoice

Number: 7616

Date: March 09, 2015

Bill To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

Ship To:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7

PO Number	Terms	Ship Via
27681		

Description	Quantity	Price	HST	Amount
Laser Metal Marking, D4802-041	6.00	4.00	✓	24.00
Laser Metal Marking, D4802-041	4.00	4.00	✓	16.00
Laser Metal Marking, D4801-042	✓ 1.00	4.00	✓	4.00
Laser Metal Marking, D4801-042	2.00	4.00	✓	8.00
Laser Metal Marking, D4928-041	4.00	4.00	✓	16.00
Laser Metal Marking, D4928-042	4.00	4.00	✓	16.00
Laser Metal Marking, D4835-041	2.00	4.00	✓	8.00
Sub-Total				\$92.00
13.00% on 92.00				11.96
Total				\$103.96

*Whatever we make, we make it the best we possibly can.
We make it as good as if we were going to keep it for ourselves.*

H.S.T. No. 13301 4258

2% INTEREST CHARGED ON OVERDUE ACCOUNTS
PAY BY INVOICE NO STATEMENT WILL BE ISSUED

Thank You